

Date: Friday, 09/01/2009 8:18:22 AM
 User: Chantal Lavoie

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEB
Job Number : 44520	
Estimate Number : 10498	
P.O. Number :	Part Number : D2739
This Issue : 09/01/2009 S.O. No. :	Drawing Number : D2739 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : SKIDTUBES	Drawing Revision : D
Previous Run : 44190	Material :
Written By :	Due Date : 16/01/2009 Qty: 4 Um: Each
Checked & Approved By : <u>09/01/09</u>	
Comment : Est Rev: C 02.11.28 Reformat KJ	
Est Rev: D 06-03-21 As Per Rev C JLM	
Est Rev: E 07-07-28 As per Rev D JLM Verified By:	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D26005108	Extrusion 'I Beam' thin
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Extrusion 'I Beam' thin

Pick:

Qty Part Number Description Batch

1 D2600-5 Web B38589

Pmc 09-01-09

2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

1-Cut D2600-5 to length as per Dwg D2739.

2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739

3-Use uni-bit to open holes to finish size as per Dwg D2739.

4-Bevel Fwd end of extrusion and Deburr holes and ends.

5-Dburr

Pmc 09-01-12

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

DP

9-1-12

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 09/01/2009 8:18:22 AM
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Seq. #:

Machine Or Operation:

Description :

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Pmc 09-01-12



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

2E 09-01-12 (4x)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Use a red or black lead-free paint pen to write the part number and batch number in the middle of each web.

Identify and Stock

Location: *LG*

Pmc 09-01-12 (4x)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/14

Job Completion



JD 09-01-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

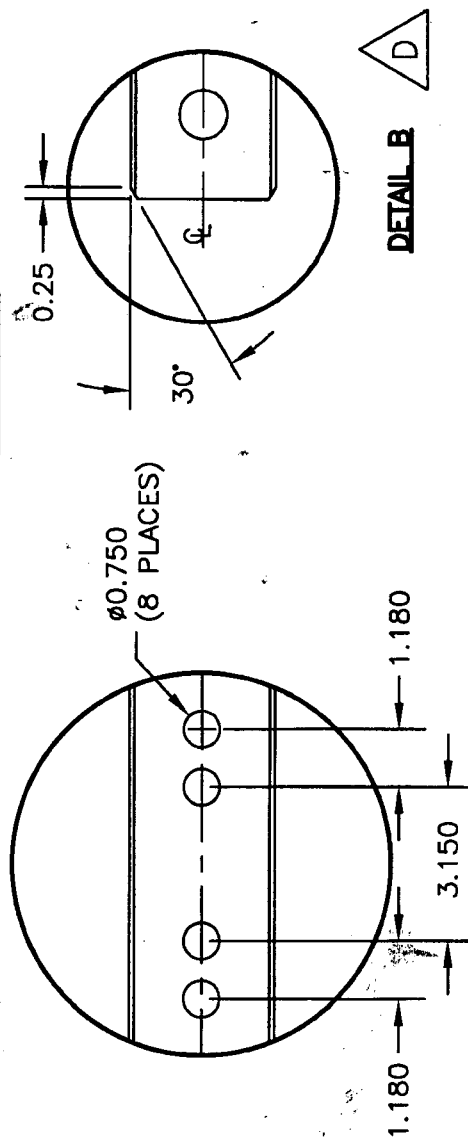
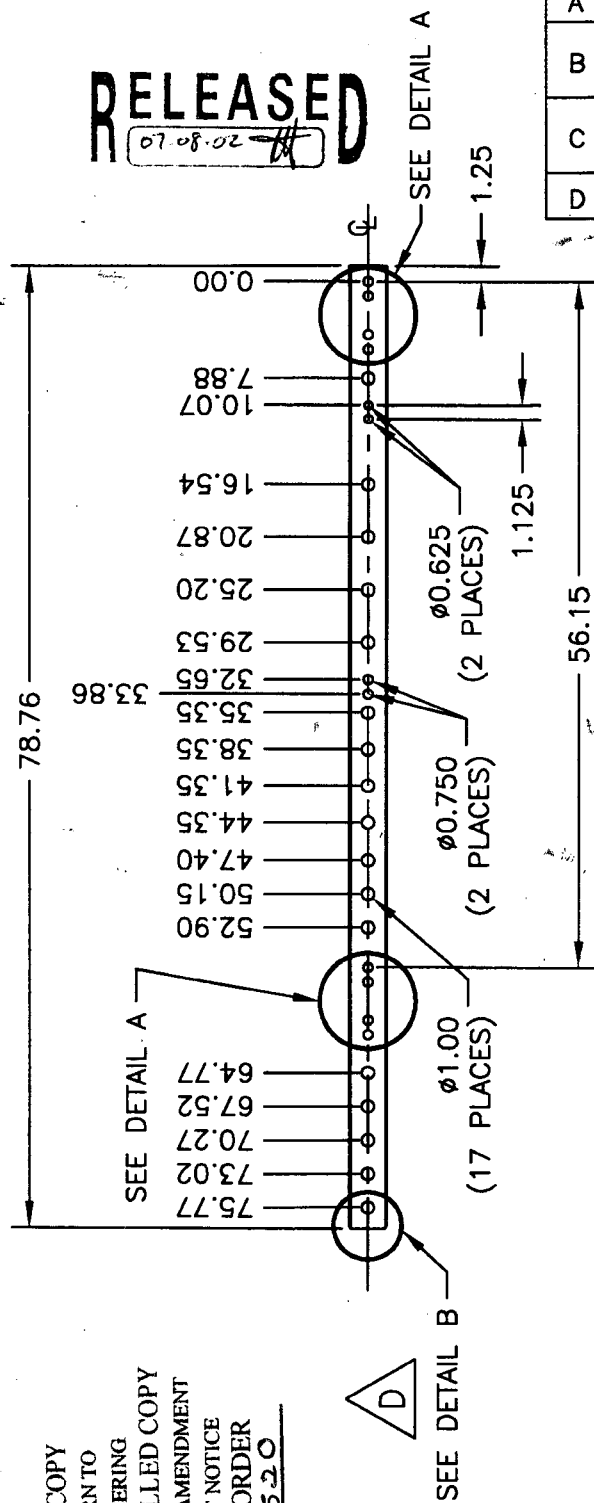
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
07-08-02

DESIGN PH		DRAWN BY CB		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH		APPROVED HA		DRAWING NO. D2739 REV. D SHEET 1 OF 1	
DATE 07.05.29		TITLE WEB		SCALE 1:15	
A	98.04.16	NEW ISSUE			
B	98.11.18	CHANGE HOLES FOR COMPATABILITY WITH AIRCRUISER FLOATS			
C	06.01.05	ADD/MOVE HOLES FOR COMPATABILITY W/APICAL FLOATS			
D	07.05.29	ADD BEVEL TO FWD END; ADD DETAIL B			



- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART OSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 4) TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRIC ABOUT C

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